

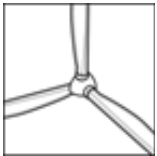
ADDITION PRODUCT INFORMATION

SikaForce®-800 Series

(formerly SikaForce®-7800 series)

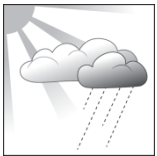
Application and curing properties

1 APPLICATION AREAS



- SikaForce®-800 Series are fast sanding surface fillers for on-site repair and maintenance of wind turbine blades
- The SikaForce®-800 Series consists of two versions called SikaForce®-800 RED and SikaForce®-800 BLUE
- Typical application areas include surface finishing and profiling of wind turbine blades prior to final coating

2 ENVIRONMENTAL CONDITIONS



- Optimum application temperatures are between 15 °C and 30 °C
- ⚠ Application outside the temperature range may significantly effect the curing behaviour of SikaForce®-800 (see also section curing and sanding)
- ⚠ High ambient temperatures in combination with high humidities may cause foaming of the product, especially if applied in very thin layers (see *Figure 1* and 2)

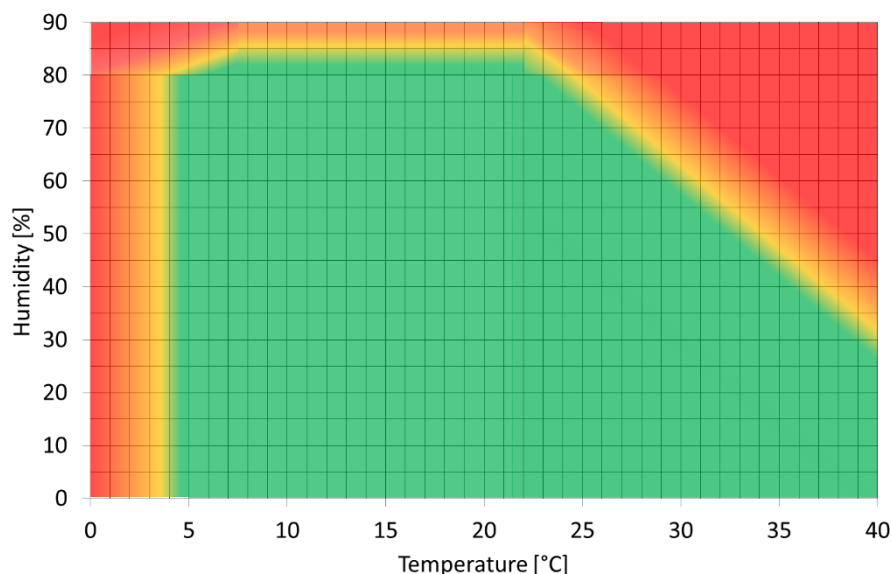


Figure 1 Suggested application window for SikaForce®-800 RED (ambient temperatures)

Additional Product Information

SikaForce®-800 series
 July 2022, Version 03
 API-SikaForce-800 Series-Application-EN-CORP-07-2022-V3-0
 Validity until July 2027, unless superseded

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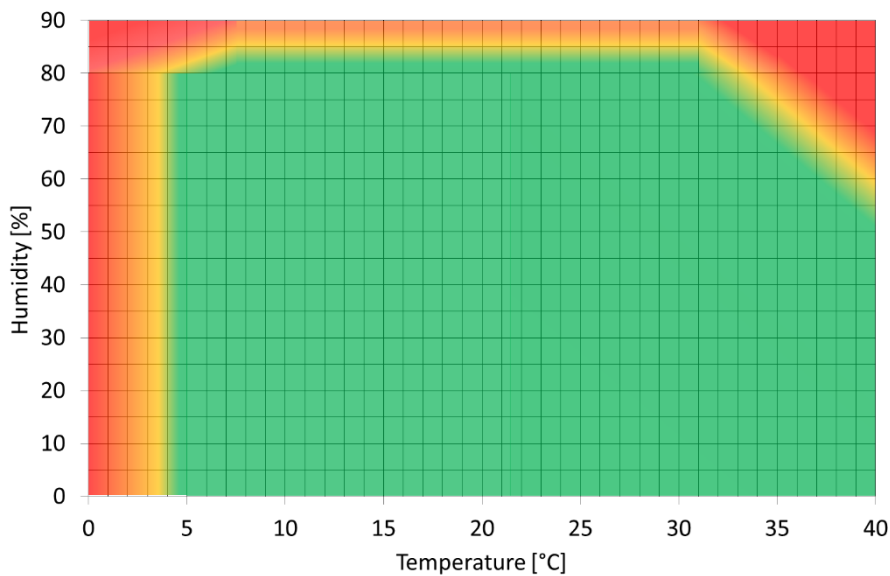


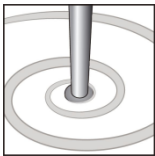
Figure 2 Suggested application window for SikaForce®-800 BLUE (ambient temperatures)

3 SURFACE PRETREATMENT



- In order to ensure good adhesion to the substrate, the surface has to be dry, free of dust and dirt or any loose particles
- If required, wipe surface with Sika® Cleaner P prior to filler application
- Apply product within 2 h after pre-treatment

4 MIXING AND APPLICATION



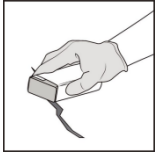
- SikaForce®-800 RED or BLUE is directly applied from coaxial cartridges through a static mixer
- Refer to the SikaForce®-800 Series mixing instruction for further details

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5 CURING AND SANDING



- The sanding time of SikaForce®-800 Series depends on ambient-, substrate- and product temperature (see figure 3 and 4)
- After curing the product can be easily sanded by hand or machine without clogging the sand paper
- The sanding time can differ at various layer thicknesses due to accelerated curing of larger volumes. The figures below show an average curing time for layer thickness of 1-3mm

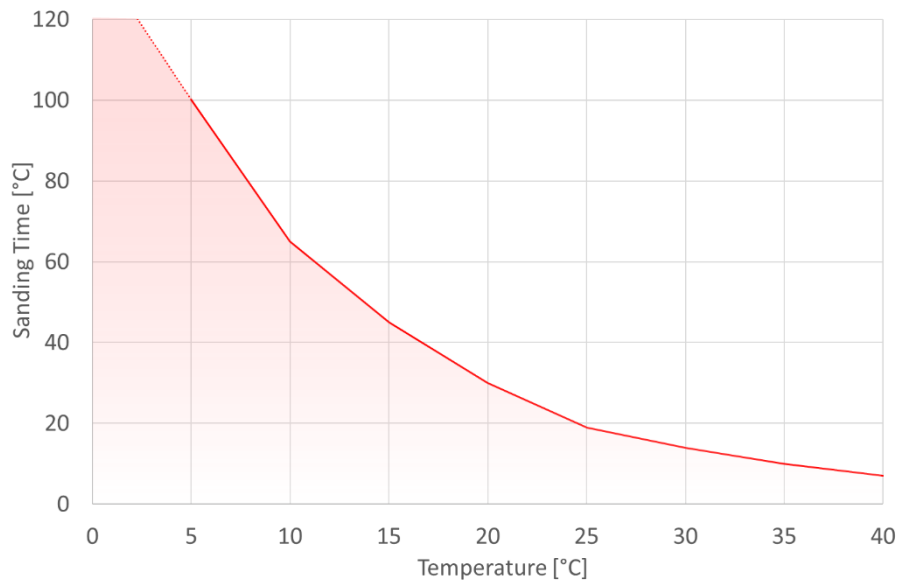


Figure 3 Indication for sanding times of SikaForce®-800RED dependent on temperature

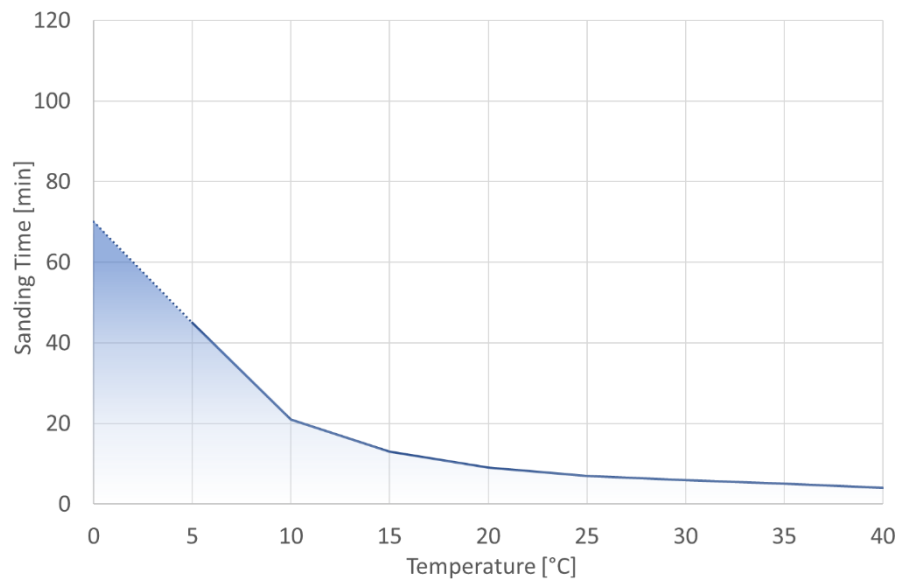


Figure 4 Indication for sanding times of SikaForce®-800BLUE dependent on temperature

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6 FURTHER INFORMATION

Copies of the following publications are available on request:

- Product Data Sheet
- Safety Data Sheet
- Additional Product Information: SikaForce®-800 Series – Mixing instruction for 2-component coaxial cartridge

Videos of mixing and application are available on Sika video platform:



Figure 5 QR-Code of [SikaForce®-800 RED](#)



Figure 6 QR-Code of [SikaForce®-800 BLUE](#)

7 HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Disclaimer

The information contained herein and any other advice are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. The information only applies to the application(s) and product(s) expressly referred to herein. In case of changes in the parameters of the application, such as changes in substrates etc., or in case of a different application, consult Sika's Technical Service prior to using Sika products. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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